

angle instead of parallel with the center-line, as in Fig. 15. This prevents the plunger from slipping after being clamped. A piece of hardened drill rod *B*, which is kept from turning by a small pin *C*, engaging a flat milled in piece *B*, is used between the plunger *A* and the clamp. A wing-nut *D* is fastened to the

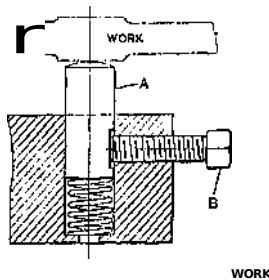


Fig. 15.
Simple
Type of
Adjustabl
e Stop

Fig. 16.
Improveme
nt on Stop
shown in
Fig. 15

end of the screw as shown, in order to eliminate the use of a wrench.

In Fig. 17 is shown another adjustable stop which presents a further improvement over that shown in Fig. 16. A bronze bushing *B* is driven into the base of the jig and allowed to pro-

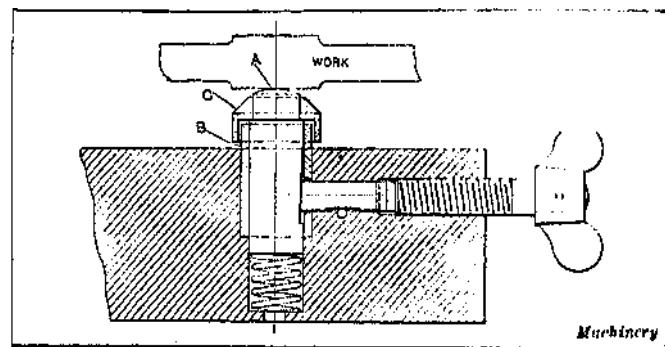


Fig. 17. A Further
Improvem
ent upon
the

**Adjustable
Stops
shown in
Figs. 15
and 16**

ject above the base, as indicated. Plunger *A* is a sliding fit in the bushing. A cap *C* is driven onto the end of the plunger and extends clown over the outside of the bushing, as indicated, making the stop dirt-proof. This stop, however, as well as that shown in Fig. 16, is not entirely satisfactory, because it will